



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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647.3916

Job Sheet 191717



Part No: 647.39

Part Name: Deflect



Part Weight: 0 lbs

Job Created: 3/6/19

Due Date: 3/15/1

Type: Stock

Note: DWG

Ship Via:

Waiting on answer
from engineers from
Apical.

Priority: Medium

lacelle

Y DD

Op
No

Operation

Qty Unit

3/15/19

0.00 0.00

ter/Supplier

Supplier Lead Time

Sign-off

100 Bandsaw - 1

2 pcs

3/15/19

0.00 0.00

Bandsaw - 1

21 2019-03-06

110 HAAS 4 Axis - B4B

2 pcs

3/15/19

0.49 4.30

HAAS - 1 - B4B

HAAS - 2 - B4B

HAAS - 3 - B4B

HAAS - 4 - B4B

120 QC 2

2 pcs

3/15/19

0.00 0.00

QC 2 - 1

QC 2 - 12

QC 2 - 14

QC 2 - 17

QC 2 - 19

QC 2 - 2

QC 2 - 20

QC 2 - 22

QC 2 - 23

QC 2 - 25

QC 2 - 32

QC 2 - 33

QC 2 - 35

QC 2 - 39

QC 2 - 4

QC 2 - 40

QC 2 - 44

QC 2 - 45

QC 2 - 48

QC 2 - 49

QC 2 - 50

QC 2 - 51

QC 2 - 52

QC 2 - 54

QC 2 - 56

QC 2 - 57

SCRAP



Container No: S159877



Part: 647.3916

Job No: 191717

Serial No/Batch: S159877

Revision:

Inspector:

Exp Date:

Instructions:

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Date: 03/06/19

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130	QC 8	2 pcs	3/15/19	0.00 0.00	QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
140	Outsource - 4 - Anodize	2 pcs	3/15/19		ATG001-VC	5
150	Packaging 2-1 - Receive - B4B	2 pcs	3/15/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	

					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
155 QC 6	2 pcs	3/15/19	0.00	0.00	QC 6 - 42	
					QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
180 Packaging 3-1 - Stock - B4B	2 pcs	3/15/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190 QC 21 - SA	2 pcs	3/15/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - (Bandsaw) Cut Blank at 16.625"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB295

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - Issue P/O to ATG : _____ Hard Anodize Color Black, Prime as per Dwg 647.3900 Rev. C

150 - (Receive & Inspect for Damage & Mat'l Certs) Mat'l Certs req'd.

155 - (QC6- All purchased or subcontracted products)

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M7075T6B4.000X03.000	7075-T6 Bar 4.000' X 3.000" see mat'l	2.7080 ft (1.354 ea)	100-Bandsaw		
	M7075T6S4.000X3.000		- 1		
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M7075T6B4.000X03.000	3	0	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Deflector, Upper Half	0.340inches + 0.000 - 0.050	0.340 0.290		
2	Deflector, Upper Half	0.063inches ± 0.005	0.068 0.058	Radius	
3	Deflector, Upper Half	0.125inches ± 0.005	0.130 0.120	Radius	
4	Deflector, Upper Half	0.188inches ± 0.005	0.193 0.183		
5	Deflector, Upper Half	0.830inches ± 0.005	0.835 0.825		
6	Deflector, Upper Half	2.000inches ± 0.005	2.005 1.995		
7	Deflector, Upper Half	0.813inches ± 0.005	0.818 0.808		
8	Deflector, Upper Half	0.063inches ± 0.005	0.068 0.058	Radius	
9	Deflector, Upper Half	0.201inches + 0.005 - 0.001	0.206 0.200	Diameter	
10	Deflector, Upper Half	65.000Degrees ± 0.500	65.500 64.500	Angle	
11	Deflector, Upper Half	0.192inches + 0.005 - 0.001	0.197 0.191	Diameter	
12	Deflector, Upper Half	20.000degrees ± 0.500	20.500 19.500	angle	
13	Deflector, Upper Half	0.196inches ± 0.010	0.206 0.186	diameter	
14	Deflector, Upper Half	0.385inches ± 0.020	0.405 0.365	diameter	
15	Deflector, Upper Half	100.000degrees ± 0.100	100.100 99.900	angle	
16	Deflector, Upper Half	0.500inches ± 0.005	0.505 0.495		
17	Deflector, Upper Half	0.460inches ± 0.005	0.465 0.455		
18	Deflector, Upper Half	1.500inches ± 0.005	1.505 1.495		
19	Deflector, Upper Half	1.500inches ± 0.005	1.505 1.495		
20	Deflector, Upper Half	1.500inches ± 0.005	1.505 1.495		

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